



ScienceDirect

journal homepage: www.elsevier.com/pisc



Design optimization of gating and feeding system through simulation technique for sand casting of wear plate[☆]



Sachin L. Nimbalkar^{a,*}, Rajendra S. Dalu^b

^a Mechanical Engineering Department, G. H. Rasoni Institute of Engineering and Management, Jalgaon, India

^b Mechanical Engineering Department, Government College of Engineering, Amravati, India

Received 15 December 2015; accepted 27 March 2016

Available online 1 April 2016

KEYWORDS

Design;
Feeder and gating;
Simulation;
Sand casting

Summary Casting is a manufacturing process to make complex shapes of metal materials; during mass production, we may experience many defects, such as gas porosity, pin holes, blow holes, shrinkages and incomplete filling that may occur in sand casting. Porosity is one of the defects most frequently encountered in ductile iron casting. Porosity impacts cost by scrap loss and limits the use of cast parts in critical high strength applications. The amount of porosity is closely related to the parameter of sand casting process. The gating/riser system design plays a very important role for improving casting quality. Many researchers reported that 90% of the defects in casting are obtained only because of improper design of gating and feeding system. The main objectives were to study the existing design of gating and feeding system, to optimize the gating and feeding system using Auto-CAST X1 casting simulation software, to prepare the sand mold and cast the part, to compare the simulated result and experimental results, to reduce rejection rate and to enable the company to again start the production.

© 2016 Published by Elsevier GmbH. This is an open access article under the CC BY-NC-ND license (<http://creativecommons.org/licenses/by-nc-nd/4.0/>).

Introduction

Casting is a manufacturing process for making complex shapes of metal materials in mass production. There are two main consecutive stages: filling process and solidification process in casting production. The filling process gating system, composed of pouring cup, runner, sprue, sprue well and ingate, is designed to guide liquid metal filling. Riser system is used to compensate shrinkage caused by casting

[☆] This article belongs to the special issue on Engineering and Material Sciences.

* Corresponding author. Tel.: +91 9503631969.

E-mail addresses: sachin.nimbalkar@gmail.com (S.L. Nimbalkar), rsdalu@gmail.com (R.S. Dalu).



Figure 1 Existing gating and feeding system with simulated results.

solidification. Casting process design is important for production quality and efficiency. It is unavoidable that many different defects occur in casting process, such as porosity and incomplete filling. As such, improvement of the casting quality becomes important. Casting quality is increasingly dependent on the success of gating/riser system design, which is currently conducted mainly relying on the technician's experience. Bad design of the gating and feeding system can result in defects in the castings. One of the main variables that should be considered when designing a gating system is the flow of molten metal while filling the mold.

Literature review

The literature review is mainly focusing on design and optimization technique based on casting related defects and their research and outcomes. Ravi and Joshi (2007) worked on computer-aided casting design and simulation of feeder and gating design of castings using Auto-CAST software and they describe how it assists in designing, modeling, simulating, analyzing and improving cast products. Bhatt and Barot (2014) suggested that the design optimization of feeding system and simulation reduced the casting defects of cast iron in foundries, which arose during solidification and mold filling. In casting processes most important is to change riser and gates dimensions and simulate with the help of Auto-CAST software. The simulation got shrinkage and reduces hot spots and cracks in gear box of automobile components. Masoumi et al. (2005) suggested the effect of gating design on mold filling for light metal casting processes. The validation results showed that the design and shape of the gate and the ratio of the gating system have a great influence on the pattern of mold filling. Hassan et al. (2012) investigated the impeller shaped casting using MAGMASOFT Software. The effect of riser and gates on parameters, such as filling pattern, pressure and speed, cooling rate, solidification and related defects, was studied. Choudhari et al. (2013) suggested that by optimization method casting related defects can be improved. The proper location, size and design of gating and feeder system using simulation technology improved the shrinkage porosity and cracks

in casting. Sun and Su (2008) suggested the numerical simulation technique, parameters of gating and riser for a magnesium alloy casting with multiple analysis characteristics in magnesium alloy base casting to analyse the effect of various gating system designs on cavity filling and casting quality using MAGMASOFT simulation software; satisfactory results were obtained with high yield and reduced shrinkage porosity. Sutaria (2010) worked on a new idea where optimization of casting feeding is done with the help of feed-paths. The computation of feed-paths is done by the method known as vector element method (VEM).

Research methodology

The entire study has been carried out in four stages, viz. design of feeder and gating system, numerical simulation by using Auto-CAST X1 software, validation with experimental results and testing by ultrasonic testing machine and finally comparing the results with old results.

As per the foundry requirement, casting material with grade SG-69-45-12 was used and mold material was taken as silica sand. The specifications of the parts of the wear plate were 342 mm length, 596 mm height, 38 mm thickness and weight around 49.50 kg. Wooden pattern was used for getting good quality of mold cavity and casting and it was easily available at a cheap rate.

Study of existing gating and feeding system

Before making a design of the gating and feeding system, mold, dies, pattern, etc., we studied the existing pattern, casted part and design of gating and feeding system of wear plate. The vertical gate and feeder were used for filling of molten metal into the cavity. Feeder was placed on the top of the plate and gate was placed at the bottom of the plate. According to the study, design was made of existing gating and feeding system using Auto-CAST X1 software and checked various results like solidification defects, hot spots, shrinkages, and mold filling, etc.; after this, sectional view was taken and we found hot spots at the center and bottom portion of the plate, which is shown in Fig. 1.

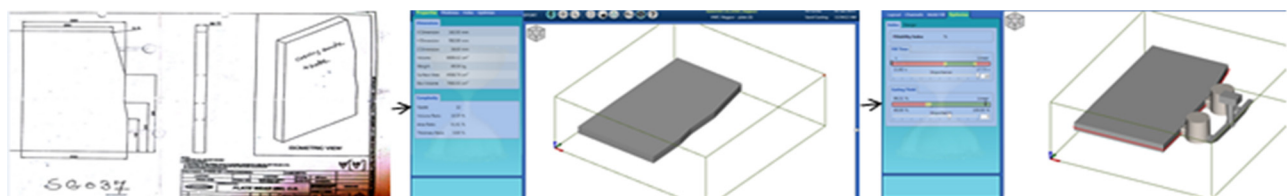


Figure 2 2D and 3D models with proposed (optimized) gating and feeding system.

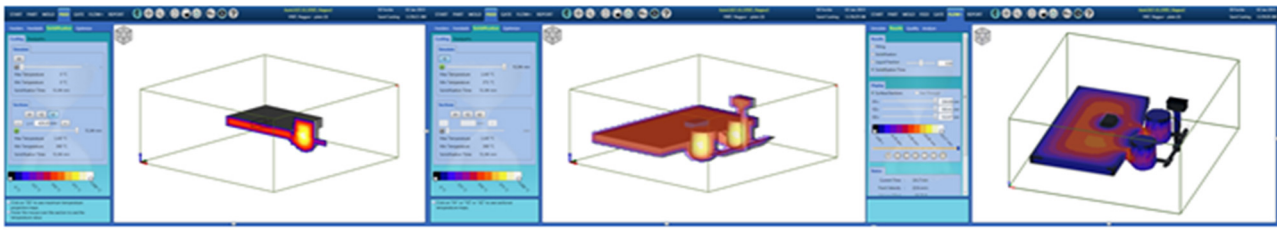


Figure 3 Solidification simulation of casting in 3D.

Design of gating and feeding system

Design of gating, feeding system and simulation was performed in Auto-CAST X1 software, which is shown as a diagrammatic representation (Fig. 2). First, wear plate part was made in Pro-E modeling software and then it was imported into Auto-CAST X1 casting simulation Software for designing of gating and feeding system. Design parameters and their calculated value were as mass of casting 58.20kg, diameter of top sprue 32 mm, bottom 32 mm and height 141 mm; runner dimensions were width 19 mm, height 19 mm and length 114 mm; feeder type was cylindrical with top diameter as 80 mm, bottom diameter 100 mm and height 100 mm.

Fig. 2 shows the 2D and 3D dimensional parts of wear plate with optimized gating and feeding system. Once the part has been imported, then mold cavity was made with parting line; after that, on applying horizontal gating (two gates) and feeding (two feeder) system, gate and feeder were located on the centerline of parting line.

Numerical simulation using Auto-CAST X1 software for wear plate

Numerical simulation based trial reduces wastage of material, labor time, energy, money, etc. Fig. 3 shows that the sectional view representing hot spots was limited to the feeder only and the casting was defects free. The second view represents 3-dimensional solidification part design (with sleeve being provided) that indicates uniform temperature gradient with no abrupt change in temperature value; the last view shows heat transfer from internal casting to the external environment. Temperature distribution was uniform in this case because gates and risers were symmetrically placed. Solidification of molten metal starts immediately after the pouring of molten metal in the cavity of mold and starts when temperature drops below 1050 °C; it is shown in reddish blue color.

Validation with experimental and ultrasonic tested results

Fig. 4 shows casted part of wear plate after removing from the mold. There were no blow holes and shrinkages found on the plate. After that, machining was done on plate at various thicknesses, like 5 mm and 10 mm, from both sides of the plate and found no pin holes and gas porosity. After that all the machined plates were checked by ultrasonic testing machine and found a lot of 10 plates, of which three plates were rejected because of pin holes.

Comparison of existing and proposed and ultrasonic testing machine results

In this section, casting yield was improved from 73.15% to 83.96%, feeding yield improved from 79.68% to 85.62% and gating yield improved from 83.46% to 96.34%. UT testing machine results of proposed (Horizontal) Gating and feeding System shows that the rejection rate was reduced from 70% to 40%, and means was minimized 30% of casting rejection. Feeding yield, gating yield and casting yield were evaluated by using following relations:

$$\text{Feeding yield} = \frac{\text{volume of casting}}{(\text{volume of casting} + \text{volume of feeder})}$$

$$\text{Gating yield} = \frac{\text{Weight of casting}}{(\text{Weight of casting} + \text{Weight of gating})}$$

$$\text{Casting yield} = \frac{\text{Weight of casting}}{(\text{Weight of casting} + \text{Weight of feeding} + \text{Weight of gating})}$$



Figure 4 Casted part with machining of plates and ultrasonic machine.

Conclusions

In this study, it was observed that solidification simulation enables and visualizes the progressive freezing from inside a casting to external environment and also identifies the last solidified regions, hot spots, metal flow rate, etc. In this case, vertical gating and feeding system was not suitable for thick casting components because many solidification defects were found inside a casting. Now, in proposed or horizontal gating and feeding system, gates and riser were placed symmetrically and flow was uniform; gases easily escaped to the atmosphere. By using casting simulation method, the percentage of rejection of casting due to gating and feeding system related defects has been reduced by 30%.

Conflict of interest

The authors declare that there is no conflict of interest.

References

- Bhatt, H., Barot, R., 2014. A design optimization of feeding system and solidification simulation for cast iron. In: *Proceeding on 2nd International Conference on Innovations in Automation and Mechatronics Engineering*, vol. 14, pp. 357–364.
- Choudhari, C.M., Padalkar, K.J., Dhumal, K.K., Narkhede, B.E., Mahajan, S.K., 2013. Defect free casting by using simulation software. *Appl. Mech. Mater.* 313–314, 1130–1134.
- Hassan, I., Sheikh, A.K., Al-Yousef, A., 2012. Mould design optimization for sand casting of complex geometries using advance simulation tools. *Mater. Manuf. Process* 27 (7), 775–785.
- Masoumi, M.H., Hu, J., Hedjazi, M., Boutorabi, A., 2005. Effect of gating design on mould filling paper. *AFS Trans.* 05-152 (2), 1–12.
- Ravi, B., Joshi, D., 2007. Feedability analysis and optimization driven by casting simulation. *Indian Foundry J.* 53 (6), 71–78.
- Sun, Zhizhong, Su, Henry, 2008. Numerical optimization of gating system parameters for a magnesium alloy casting with multiple performance characteristics. *J. Mater. Sci. Technol.* 18, 256–264.
- Sutaria, M., 2010. Casting simulation case study: shaft pin (cast iron-green sand casting). *Indian Foundry J.* 56 (12), 5.